



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2563

Job Sheet 173125



Part No: D2563

Job Qty: 3 ea

Part Name: Step Weldment Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/26/18

Job Tracking No:

Due Date: 3/12/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG REV C IPP Rev:G 02.07.31 Re-format Location RF

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	3 Ea		3/9/18	0.00	0.00	Start Up Large Fab-2		
100	Large Fab	3 pcs		3/10/18	0.00	4.41	Large Fab 2		11/18-3-2
110	QC	3 pcs		3/10/18	0.00	0.00	QC9		CPC
120	QC	3 pcs		3/10/18	0.00	0.00	QC5		CPC
130	HandFinish	3 pcs		3/10/18	0.00	0.81	HandFinish1		SA 18-3-6
140	QC	3 pcs		3/10/18	0.00	0.00	QC7		CPC
150	Large Fab	3 pcs		3/10/18	0.00	4.41	Large Fab 2		18-3-6
160	QC	3 pcs		3/10/18	0.00	0.00	QC10		38 DAS
170	QC	3 pcs		3/10/18	0.00	0.00	QC5		9-88 38
175	HandFinish	3 pcs		3/10/18	0.00	0.81	HandFinish2		SA 18-3-6
180	Powdercoat	3 pcs		3/10/18	0.00	0.50	Powdercoat1		BR 18-3-12
190	HandFinish	3 pcs		3/12/18	0.00	0.81	HandFinish3		BE 18-3-13
200	QC	3 pcs		3/12/18	0.00	0.00	QC3		DAS
210	Packaging	3 pcs		3/12/18	0.00	0.00	Packaging3		21
220	QC21-SA	3 Ea		3/12/18	0.00	0.00	QC21		9-88

Part Op 100 - 1-Cut D2244 to 89.70" at 34 deg as per dwg D2563 2-Deburr ends 3-Weld (1 END CAP, LUG PLATES & DESCRIPTIONS: MOUNTING ANGLE) as per dwg D2563 using DT 8343 4- Grind

150 - 1-Inspect for foreign object per QSI 024 2-Weld Remaining End cap as per Dwg D2563 using DT 8343 3-Grind

175 - Touch up Alodine as per QSI005

180 - Touch up Alodine then Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 START TIME: _____

M 138760 START: 1:25 OUT: 3:00 FINISH: 4:55

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2244-116	Step Extrusion	3 Ea (1 ea)	90-Start up Operation	5014558
D2561	Lug	6 Ea (2 ea)	90-Start up Operation	5068703
D2564	Mounting Angle	6 Ea (2 ea)	90-Start up Operation	5042481
D2673-34	End Plate	3 Ea (1 ea)	90-Start up Operation	5160473/2x
D2673-34	End Plate	3 Ea (1 ea)	150-Large Fab	5042088

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2244-116	3	171	0
	D2561	6	26	0
	D2564	6	21	0
	D2673-34	3	25	0
	D2673-34	3	25	0

Part Specifications

Specifications could not be found.

Plex 2/26/18 12:19 PM Dart.Gagnon.Michelle



Container No: S047318



Part: D2563

Job No: 173125

Serial No/Batch: S047318

Revision:

Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 03/02/18